

Date: Tuesday, 15/07/2008 4:13:30 PM
User: Julie Lecocq

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : AFT TUBE ASSEMBLY
Job Number : 40526
Estimate Number : 10699
P.O. Number :
This Issue : 15/07/2008 S.O. No. :
Prsht Rev. : NC Part Number : D3391025
First Issue : / / Type : SKIDTUBES Drawing Number : D3391 REV G
Previous Run : 40525 Project Number : N/A
Drawing Revision : G
Material :
Due Date : 08/08/2008 Qty: 1 Um: Each

Written By :

Checked & Approved By :

Comment : Est Rev B 06-02-07 ECN773 dwg rev. D EC
Est Rev:C 06-03-28 Update Manuf. Instructions JLM

est rev D 07.03.20 revF dwg. EC
est rev E 07.11.07 rev G dwg ecn 1053p EC verified by:
DD
Est Rev:F 07-11-13 ECN 1056 DD verified by: EC

Additional Product

Job Number:

Seq. #: Machine Or Operation: Description :

1.0 D6014090 ALUMINUM EXTRUSION

Comment: Qty.: 1.0000 f(s)/Unit Total: 1.0000 f(s)

ALUMINUM EXTRUSION

Pick:

Qty Part Number Description Batch

1 D6014-090 Extrusion B32309

Identify as D3391-3

2.0 MORI SEIKI MORI SEIKI CNC LATHE LARGE

Comment: MORI SEIKI CNC LATHE LARGE

Turn as per Folio FA599

Rev: AA & Dwg D3391 Rev: A

3.0 QC2 INSPECT PARTS AS THEY COME OFF MACHINE

Comment: INSPECT PARTS AS THEY COME OFF MACHINE

4.0 HAAS1 HAAS CNC VERTICAL MACHINING #1

Comment: HAAS

1-Machine as per Folio FA 599 Rev: AA & Dwg D3391 Rev: G

2-Deburr

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D3391-025 PAR #: N/A Fault Category: Prod / Machined Part NCR: (Yes) No DQA: D Date: 08/10/03
 QA: N/C Closed: D Date: 08/10/03

NCR: <u>40526</u>		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
8/7/29	2.0	During machining / Boreing of the 3.500" ID Die Bore the tube started to chatter causing large score at 9" from the end.	<i>[Signature]</i> 08/07/29	Scrub and Destroy and Replse in this workorder Qty @ B# B32309	A.M 08-07-31 06/07/28	<i>[Signature]</i> 08/07/31	<i>[Signature]</i> 08/07/29	<i>[Signature]</i> 08/07/29
		RC Feed had to be adjusted and build it of chips in tube		- ensure tube is cleared out before each Pass with the Borey Bore				<i>[Signature]</i> 08/07/29

NOTE: Date & initial all entries

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Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: AFT TUBE ASSEMBLY

Job Number: 40526

Part Number: D3391025

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

QC2

INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

J.L 08/08/05

6.0

QC8

SECOND CHECK



Comment: SECOND CHECK

J.F. 08/08/05 (1)

7.0

SKIDTUBES 1

SKIDTUBESS RESOURCE 1



Comment: LANDING GEAR RESOURCE 1

1-Drill (PILOT HOLE) aft cap holes per Dwg D3391 using DT8803

DP 8-8-5

8.0

BENDING

BENDING MACHINE - SKIDTUBES



Comment: NC Bender

Form as per Dwg D3391 Using Bend Prog 3391025

DP 8-8-5

9.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

8-8-5

10.0

SKIDTUBES 1

SKIDTUBESS RESOURCE 1



Comment: LANDING GEAR RESOURCE 1

1-Open Aft cap pilot hole to .208" as per Dwg D3391

2-Drill float bag holes using DT8809 as per Dwg D3391(Holes marked "A" Only.

3-Drill wearplate holes as per Dwg D3391 using DT8878(Mid Tube) & DT8217 Wearplate Jig .

*****Do Not Open To Finished Size*****

4-Drill Wearshoe holes as per DWG D3391 using DT8939 locating from 2 previously drilled aft wearplate holes.

5-Open wearplate holes to 0.250" and c'sink as per dwg D3391

6-Open up all wearshoe , wearplate and float bag holes as per Dwg D3391.

7-Deburr

M 8-8-6
M 8-8-8

Tools: rill

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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Drawing Name: AFT TUBE ASSEMBLY

Job Number: 40526

Part Number: D3391025

Job Number:



Seq. #:

Machine Or Operation:

Description :

11.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

S 08/08/12 (X)

12.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



ANM 5-8-14



Comment: HAND FINISHING RESOURCE #1

Acid etch and Alodine as per QSI 005 4.1

13.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

H 7-7-15

14.0

D36704200

SPACER



Comment: Qty.: 4.0000 Each(s)/Unit Total: 4.0000 Each(s)

SPACER

batch:

D36704

(4) H 7-7-15

15.0

SKIDTUBES 1

SKIDTUBESS RESOURCE 1



Comment: LANDING GEAR RESOURCE 1

Instal spacers as per dwg D3391

A/R Magnabond 6398

Batch: M107621

exp. date: 2-2-1

cure time 12hrs as per QSI0015

H 7-7-15

16.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

S 08/08/12 (X)

17.0

POWDER COATING

POWDER COATING



M108523



(1X)

Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

START TIME:

1:40

OVEN TEMPERATURE:

320

FINISH TIME:

2:10

M. 08/08/19

M108523

START: 11:15

Temp: 320°F

Finish: 11:45

9/ 08-08-15 (X)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: AFT TUBE ASSEMBLY

Job Number: 40526

Part Number: D3391025

Job Number:



Seq. #:

Machine Or Operation:

Description :

18.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

08-08-19 (X)

19.0

D2646

Aft Cap



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Aft Cap

Pick:

Qty Part Number Description Batch
1 D2646 Aft Cap

B32127

M-L

20.0

D35371

Wearpad



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)
WEARPAD

B38941

M-L

21.0

D35377

Wearpad



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)
Wearpad

B33869

M-L

22.0

D35531

Gasket



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)
Gasket

B31630

M-L

23.0

D35533

Gasket



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)
Gasket

B33870

M-L

24.0

D36721

Phenolic Washer



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)
PHENOLIC WASHER

B39275

M-L

25.0

ALS41032130

Insert



Comment: Qty.: 14.0000 Each(s)/Unit Total : 14.0000 Each(s)

INSERT

batch: M105819

M-L

08/09/11

(IX)

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

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Drawing Name: AFT TUBE ASSEMBLY

Job Number: 40526

Part Number: D3391025

Job Number:



Seq. #:

Machine Or Operation:

Description :

or equivalent per
QSI 017

26.0

ALS41032225

Insert



Comment: Qty.: 12.0000 Each(s)/Unit Total : 12.0000 Each(s)

INSERT

or equivalent
Per QSI 017

M100489

M. H

27.0

AN3C4A

BOLT



Comment: Qty.: 6.0000 Each(s)/Unit Total : 6.0000 Each(s)

Bolt

Pick:

Qty Part Number Description Batch
2 AN3C4A Bolt

M109148

M. H

28.0

AN3C5A

Bolt



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Bolt

M108744

M. H

29.0

AN960C10L

washer



Comment: Qty.: 10.0000 Each(s)/Unit Total : 10.0000 Each(s)

Inventory

Pick:

Qty Part Number Description Batch
2 AN960C10L Washer

M109147

M. H

30.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



(1X)

Comment: SMALL & MEDIUM FAB RESOURCE 1

1-Install inserts as per Dwg D3391

2-Install Aft Cap as per Dwg D3391

A/R Sikaflex-241/-291

Sikaflex expiry date:

M108801

08/10

M. H 08/04/11

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

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Drawing Name: AFT TUBE ASSEMBLY

Job Number: 40526

Part Number: D3391025

Job Number:



Seq. #:

Machine Or Operation:

Description :

31.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

5 08/02/16 (40)

32.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location:

RPP 40564

8/10/11

(10)

34

33.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

08/10/02 40

Job Completion



MF 08-10-02

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order: 405260
Description: Float Skidtube (412)		Part Number: D3391-3
Inspection Dwg: D3391	Rev: G	Page 1 of 1

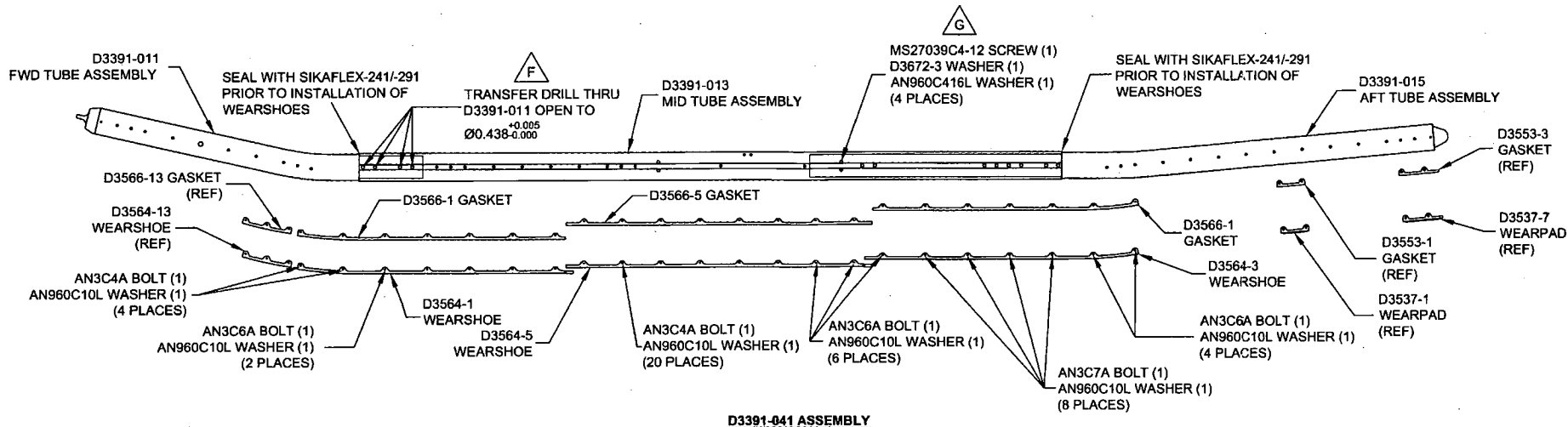
FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
14.000	+/-0.010	14.000	✓			
3.500	+/-0.010	3.502	✓			
88.93	+/-0.030	8.920	✓			
44.995	+/-0.030	44.995	✓			
3.200	+/-0.010	3.202	✓			
1.526	+0.000/-0.030	1.515	✓			
0.200	+/-0.010	.203	✓			
7.500	+/-0.010	7.500	✓			
27.750	+/-0.010	27.750	✓			
31.750	+/-0.010	31.750	✓			
35.250	+/-0.010	35.250	✓			
3.300	+/-0.010	3.300	✓			
0.200	+/-0.010	.200	✓			
3.520	+/-0.010	3.526	✓			
0.687	+0.010/-0.000	.688	✓			
R0.062	+/-0.010	.062	✓			
Ø0.484	+0.005/-0.001	.486	✓			

Measured by: a.m./JL	Audited by: J.F.	Prototype Approval:	N/A
Date: 08.07.30	Date: 08/08/25	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	06.04.24	New Issue P/O D3391-015/-025	KJ/JLM	
B	06.06.19	Dwg revision update	KJ/JLM	
C	07.04.20	Ø0.208 dimension removed	KJ/JLM	
D	07.09.06	0.400 dimension removed	KJ/JLM	
E	07.11.23	Dwg Rev. updated	KJ/EC/DD	



D3391-041 ASSEMBLY

RELEASED
27-11-06

D3391-041 FLOAT SKIDTUBE ASSEMBLY PARTS LIST

QTY	PART NUMBER	DESCRIPTION
1	D3391-041	FLOAT SKIDTUBE ASSEMBLY
1	D3391-011	FWD TUBE ASSEMBLY
1	D3391-013	MID TUBE ASSEMBLY
1	D3391-015	AFT TUBE ASSEMBLY
1	D3564-1	WEARSHOE
1	D3564-3	WEARSHOE
1	D3564-5	WEARSHOE
2	D3566-1	GASKET
1	D3566-5	GASKET
4	D3672-3	WASHER
24	AN3C4A	BOLT
12	AN3C6A	BOLT
8	AN3C7A	BOLT
1	AN960C10L	WASHER
1	MS27039C4-12	SCREW
1	AN960C416L	WASHER

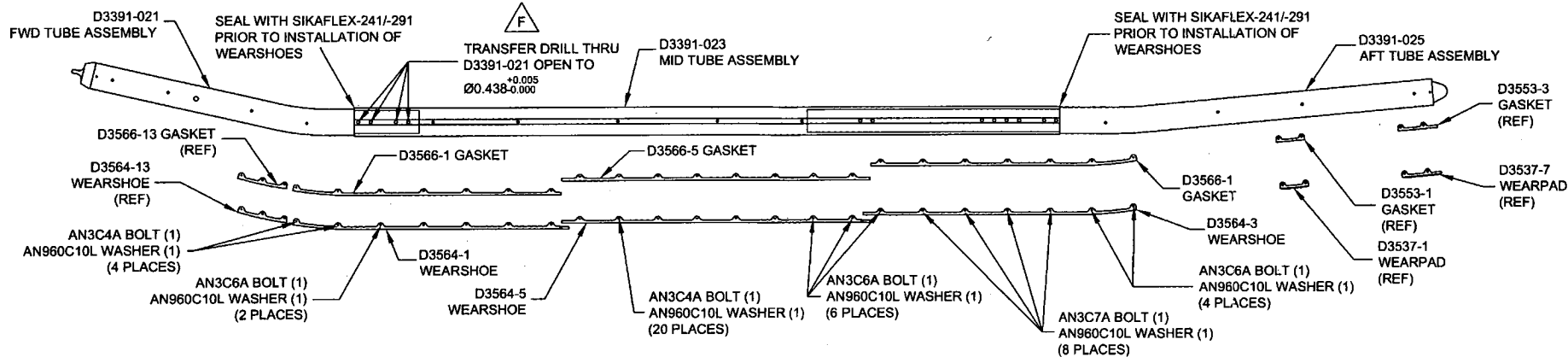
GENERAL NOTES

- 1) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
- 2) SPRAY INSIDE OF TUBE WITH A COAT OF LPS LABORATORIES "LPS-3" AFTER FINISH
AND AFTER INSTALLATION OF INSERTS. COAT ALL EXPOSED FASTENERS WITH
LPS LABORATORIES "LPS PROCYON" AFTER FINAL ASSEMBLY, CLEAN EXCESS
OFF POWDER COATING WITH MEK DEGREASER.
TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) UNITS: INCHES UNLESS OTHERWISE NOTED
- 4) USE DART DRILL TEMPLATE DT8217 TO LOCATE AND DRILL Ø0.297 SIZE HOLES
FOR WEARSHOE INSERTS. CBORE AS NOTED AND INSTALL INSERTS EXCEPT
WHERE INDICATED.

G	REPLACE NAS INSERTS W/ AELS INSERTS SWITCH TO D3670-XXXX SPACERS FOR INSTALLING FLOAT BAGS, DWG REORGANIZED FOR CLARITY	DC	07.07.31
F	ADD SS WEARSHOE, GASKET REMOVE FWD SADDLE HOLE -011/-021	PH	07.01.18
E	CHANGE TOLERANCE, EASE MANUFACTURE	PH	06.04.25
D	UPDATE TOLERANCE, CHANGE HOLE SIZE	PH	06.01.23
C	LENGTHEN AFT EXTENSION	PH	05.09.27
B	DRAWING UPDATES	PH	05.06.10
A	NEW ISSUE	PH	05.02.07
REV.	DESCRIPTION	BY	DATE
DESIGN	PH	DART AEROSPACE USA, INC PORT HADLOCK, WA DRAWING NO. D3391 TITLE 412 FLOAT SKIDTUBE SCALE NTS COPYRIGHT © 2005 BY DART AEROSPACE USA, INC <small>THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.</small>	
DRAWN	SP		
CHECKED	SP		
MFG. APPR.	SP		
APPROVED	SP		
DE APPR.	SP		
DATE	07.07.31		

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W. K. STEEB
SALT LAKE CITY
CHURCH OF THE HOLY
TRINITY
SALT LAKE CITY
UTAH



RELEASED
07-11-94

D3391-043 FLOAT SKIDTUBE ASSEMBLY PARTS LIST

QTY	PART NUMBER	DESCRIPTION
X	D3391-043	FLOAT SKIDTUBE ASSEMBLY
1	D3391-021	FWD TUBE ASSEMBLY
1	D3391-023	MID TUBE ASSEMBLY
1	D3391-025	AFT TUBE ASSEMBLY
1	D3564-1	WEARSHOE
1	D3564-3	WEARSHOE
1	D3564-5	WEARSHOE
2	D3566-1	GASKET
1	D3566-5	GASKET
24	AN3C4A	BOLT
12	AN3C6A	BOLT
6	AN3C7A	BOLT
44	AN960C10L	WASHER

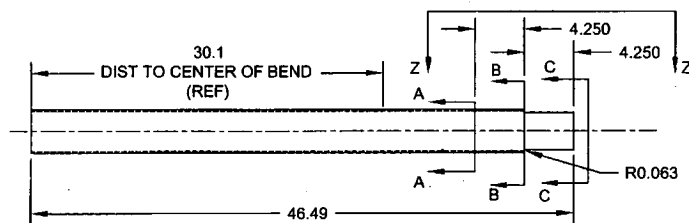
GENERAL NOTES

- 1) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
- 2) SPRAY INSIDE OF TUBE WITH A COAT OF LPS LABORATORIES "LPS-3" AFTER FINISH AND AFTER INSTALLATION OF INSERTS. COAT ALL EXPOSED FASTENERS WITH LPS LABORATORIES "LPS PROCYON" AFTER FINAL ASSEMBLY, CLEAN EXCESS OFF POWDER COATING WITH MEK DEGREASER.
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) USE DART DRILL TEMPLATE DT8217 TO LOCATE AND DRILL Ø0.297 SIZE HOLES FOR WEARSHOE INSERTS. C'BORE AS NOTED AND INSTALL INSERTS EXCEPT WHERE INDICATED.

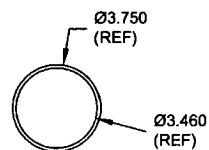
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DRAWN	SLC	PORT HADLOCK, WA	
CHECKED	h	DRAWING NO.	REV. G
MFG. APPR.	h	D3391	SHEET 2 OF 8
APPROVED	h	TITLE	SCALE
DE APPR.	h	412 FLOAT SKIDTUBE	NTS
DATE	07.07.31	<small>COPYRIGHT © 2005 BY DART AEROSPACE USA, INC THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSES OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.</small>	

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NO. 40520

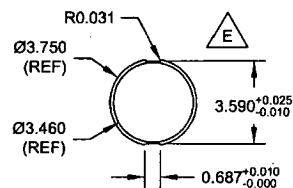
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OF THE
BUREAU OF
MILITARY SERVICE



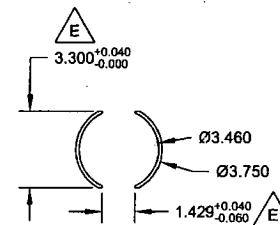
D3391-1 CUTTING DETAIL
(MAKE FROM D6013-047 SKIDTUBE MATERIAL)



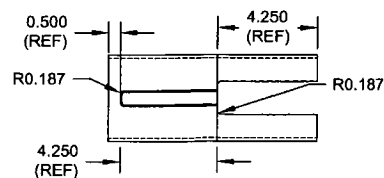
SECTION A-A
(SCALE 1:5)



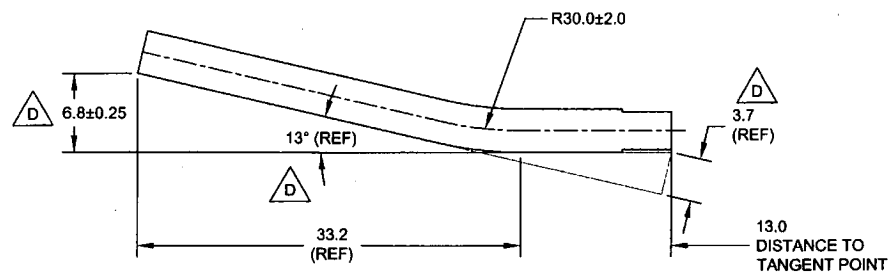
SECTION B-B
(SCALE 1:5)



SECTION C-C
(SCALE 1:5)



VIEW Z-Z
(SCALE 1:5)



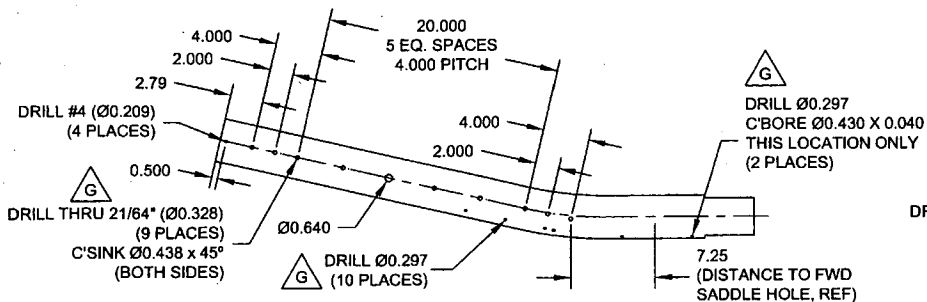
D3391-011/-021 BENDING DETAIL
(MAKE FROM D3391-1)

RELEASED
07-11-06

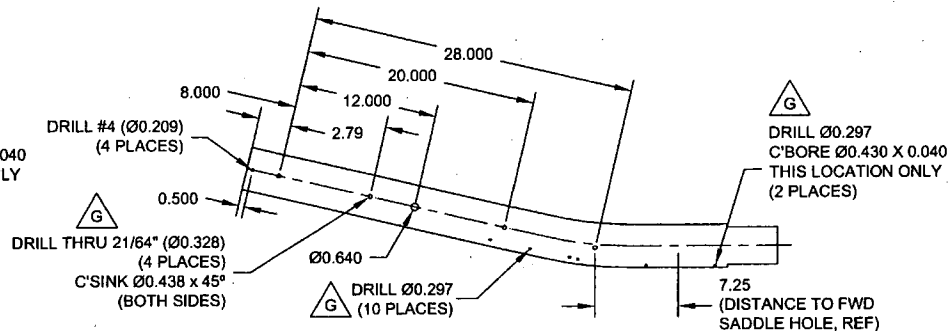
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DESIGN		DART AEROSPACE USA, INC	
DRAWN		PORT HADLOCK, WA	
CHECKED		DRAWING NO.	REV. G
MFG. APPR.		D3391	SHEET 3 OF 8
APPROVED		TITLE	SCALE
DE APPR.		412 FLOAT SKIDTUBE	1:10
DATE	07.07.31	<small>COPYRIGHT © 2005 BY DART AEROSPACE USA, INC. THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.</small>	

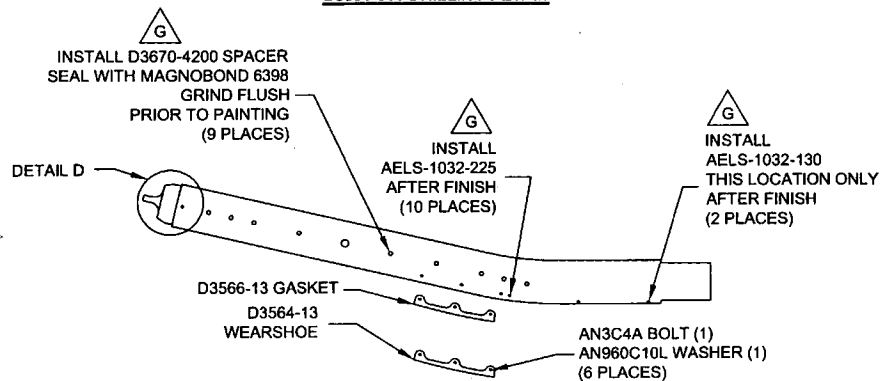
2
1
MAY 19 1964
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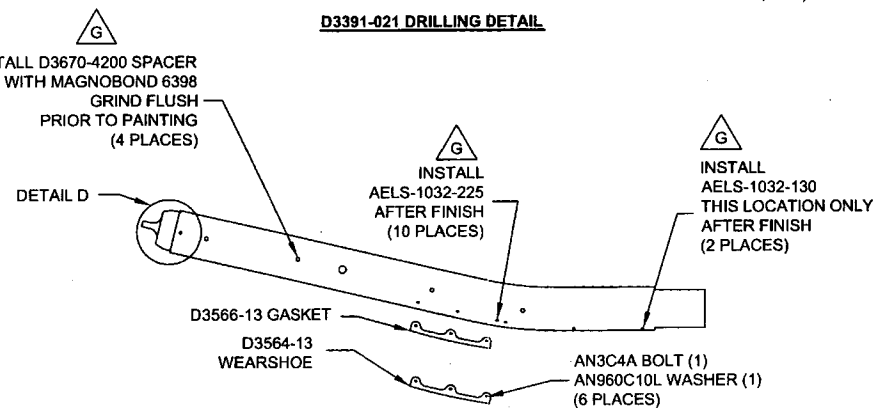
D3391-011 DRILLING DETAIL



D3391-021 DRILLING DETAIL



D3391-011 ASSEMBLY DETAIL

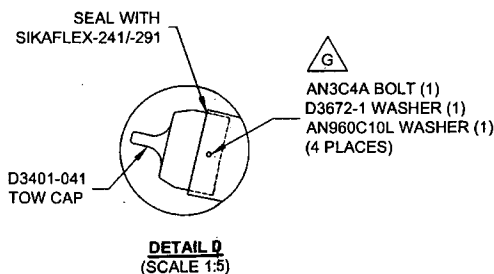


D3391-021 ASSEMBLY DETAIL

RELEASED
07-11-06

D3391-011/-021 FWD TUBE ASSEMBLY PARTS LIST

QTY - 011	QTY - 021	PART NUMBER	DESCRIPTION
X		D3391-011	FWD TUBE ASSEMBLY
	X	D3391-021	FWD TUBE ASSEMBLY
1	1	D6013-047	FWD TUBE
1	1	D3401-041	TOW CAP
1	1	D3564-13	WEARSHOE
1	1	D3566-13	GASKET
9	4	D3670-4200	SPACER
4	4	D3672-1	WASHER
10	10	AN3C4A	BOLT
10	10	AN960C10L	WASHER
2	2	AELS-1032-130	INSERT
10	10	AELS-1032-225	INSERT



DESIGN		DART AEROSPACE USA, INC
DRAWN		PORT HADLOCK, WA
CHECKED		DRAWING NO. D3391
MFG. APPR.		REV. G SHEET 4 OF 8
APPROVED		TITLE 412 FLOAT SKIDTUBE
DE APPR.		SCALE 1:10
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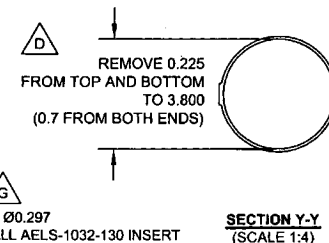
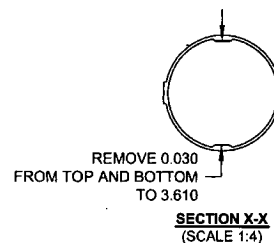
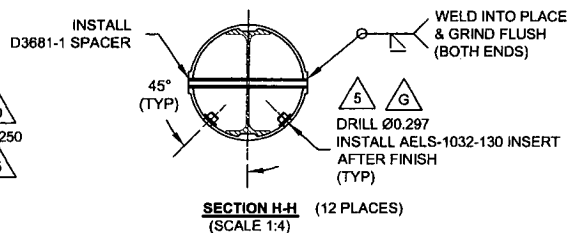
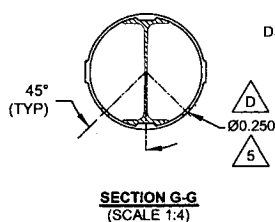
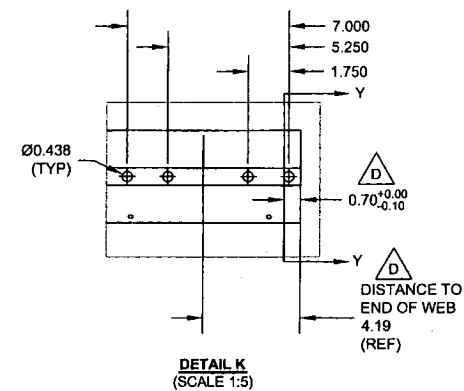
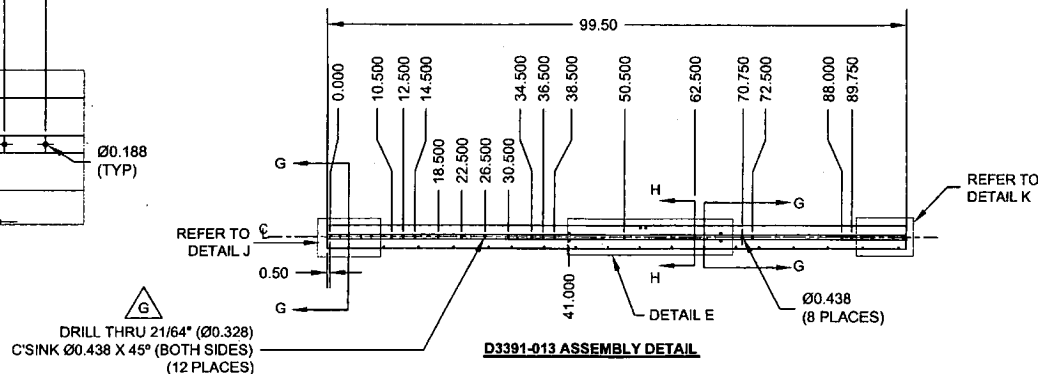
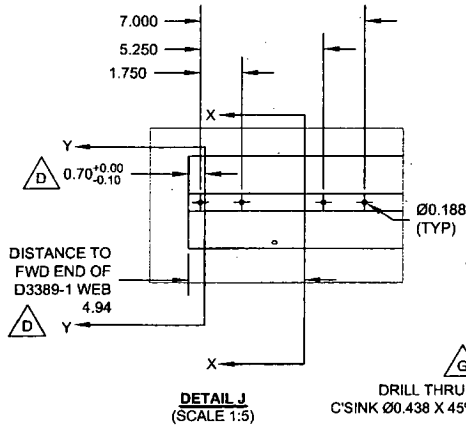
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POLICE

NEW YORK

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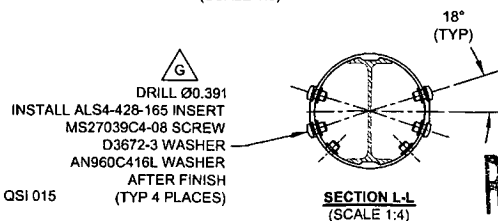
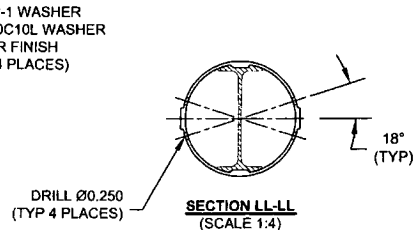
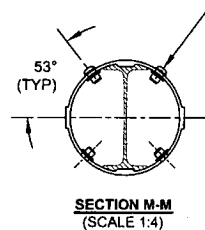
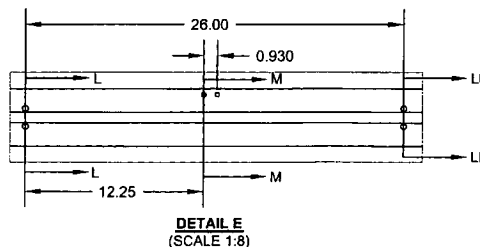
NEW YORK

NEW YORK



D3391-013 MID TUBE ASSEMBLY PARTS LIST

QTY	PART NUMBER	DESCRIPTION
-013		
X	D3391-013	MID TUBE ASSEMBLY
1	D2500-1-100	EXTRUSION
1	D3389-1	WEB
12	D3681-1	SPACER
4	D3672-1	WASHER
4	D3672-3	WASHER
24	AELS-1032-130	INSERT
4	ALS4-428-165	INSERT
4	AN960C10L	WASHER
4	AN960C416L	WASHER
4	MS27039C1-09	SCREW
4	MS27039C4-08	SCREW



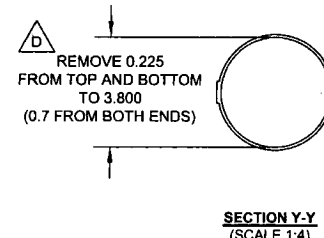
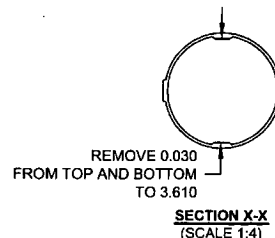
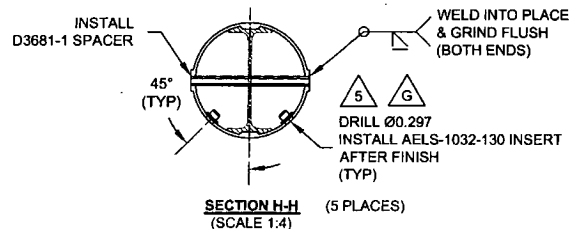
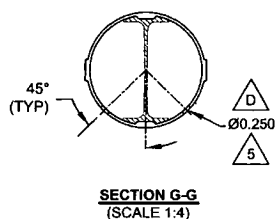
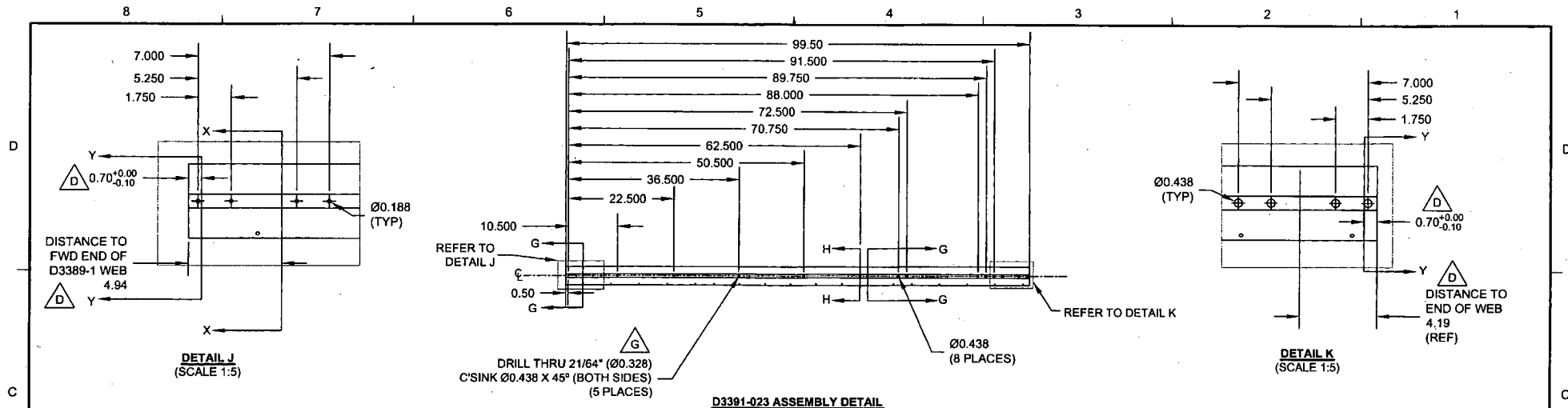
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CHECKED	DF	DRAWING NO.	REV. G
MFG. APPR.	DF	D3391	SHEET 5 OF 8
APPROVED	DF	TITLE	SCALE
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21.11.2017

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- 1) MATERIAL: MAKE FROM D2500-1-100 EXTRUSION
- 2) INSTALL D3389-1 WEB TO OUTER TUBE USING SIKAFLEX-241/291 PER QSI 015
- 3) FINISHING: PER DART QSI 004

IN THE
COURT OF
COMMON PLEAS
FOR THE COUNTY OF
MIDDLESEX
DOVER
1900



D3391-023 MID TUBE ASSEMBLY PARTS LIST

QTY -	PART NUMBER	DESCRIPTION
023		
X	D3391-023	MID TUBE ASSEMBLY
1	D2500-1-100	EXTRUSION
1	D3389-1	WEB
5	D3681-1	SPACER
20	AELS-1032-130	INSERT

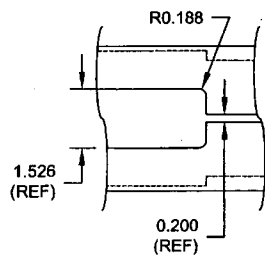
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MFG. APPR.	SP	D3391 SHEET 6 OF 8
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DE APPR.	SP	412 FLOAT SKIDTUBE 1:20
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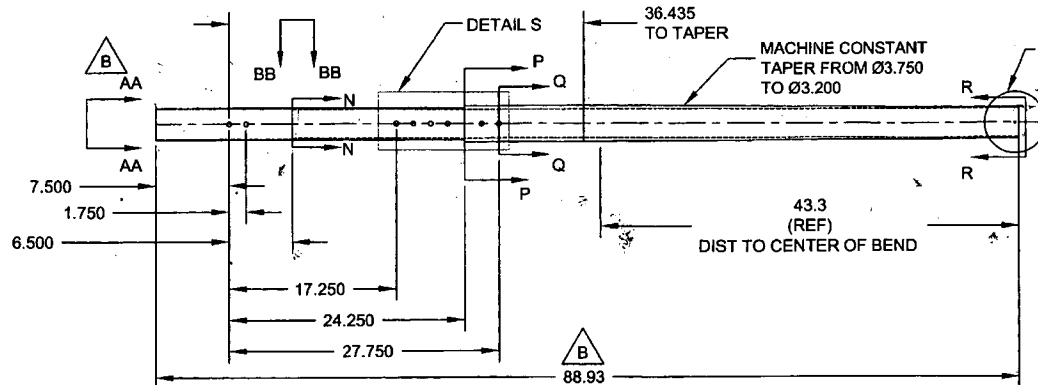
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D3391-023 MID TUBE ASSEMBLY
MATERIAL: MAKE FROM D2500-1-100 EXTRUSION
(1) INSTALL D3389-1 WEB TO OUTER TUBE USING SIKAFLEX-241/291 PER QSI 015
(2) WELD G-SPACER PART QSI 004

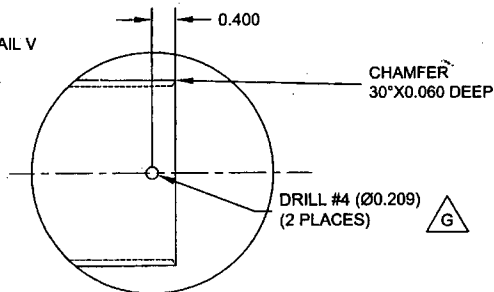
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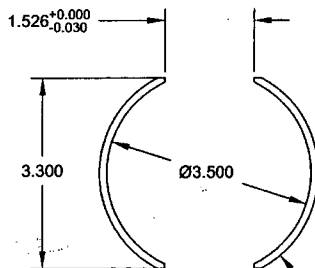
VIEW BB-BB
(SCALE 1:3)



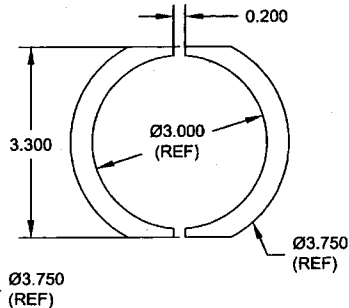
D3391-3 AFT DRILLING AND CUTTING DETAIL
(MAKE FROM D6014-090 SKIDTUBE MATERIAL)



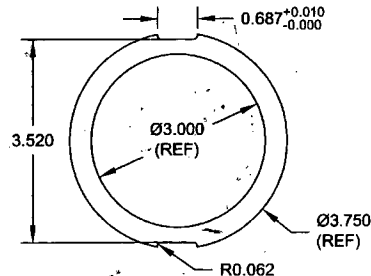
DETAIL V
(SCALE 1:2)



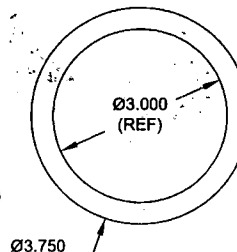
SECTION AA-AA
(SCALE 1:2)



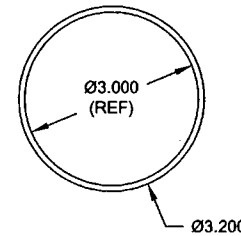
SECTION N-N
(SCALE 1:2)



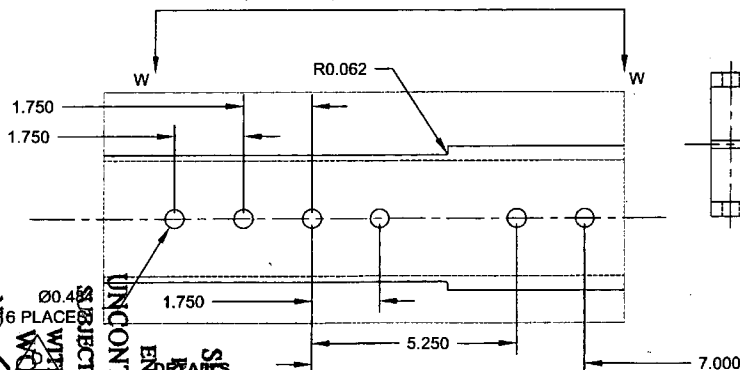
SECTION P-P
(SCALE 1:2)



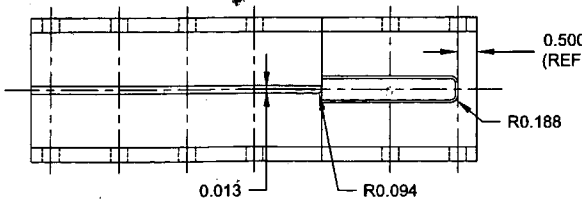
SECTION Q-Q
(SCALE 1:2)



SECTION R-R
(SCALE 1:2)



VIEW W-W
(SCALE 1:3)

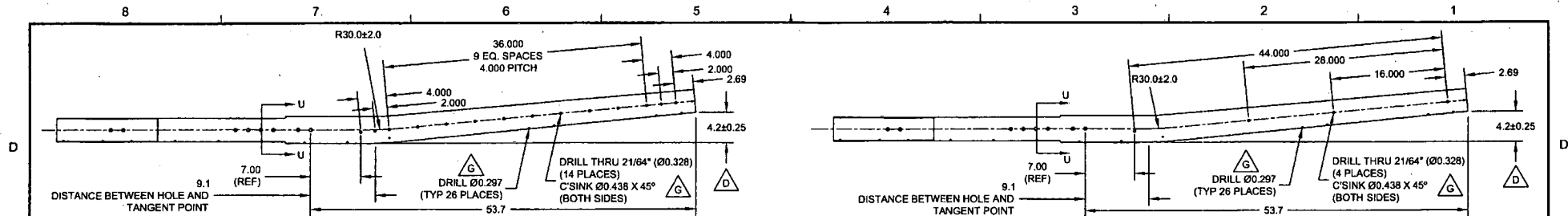


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07-11-06

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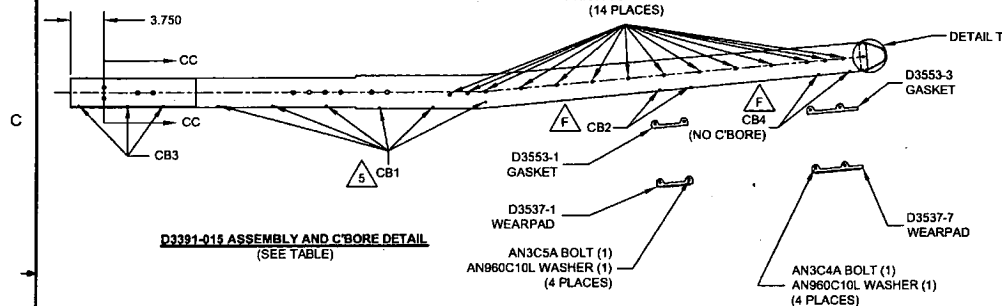
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FOR THE BETTER OF ALL
THE PEOPLE
OF THE WORLD



D3391-015 BENDING AND DRILLING DETAIL
(SEE C'BORE DETAIL BELOW)

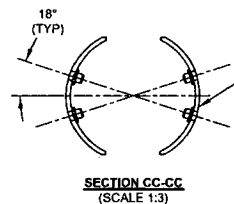
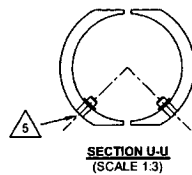
INSTALL D3670-4200 SPACER
SEAL WITH MAGNOBOND 6398
GRIND FLUSH
PRIOR TO PAINTING
(14 PLACES)



D3391-015 ASSEMBLY AND C'BORE DETAIL
(SEE TABLE)

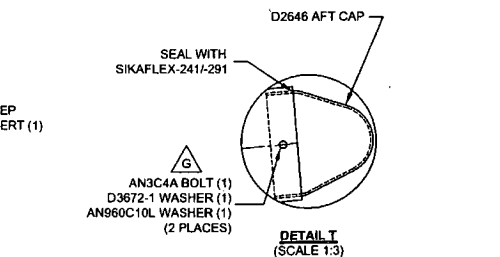
D3391-015/-025 AFT TUBE ASSEMBLY PARTS LIST

QTY - 015	QTY - 025	PART NUMBER	DESCRIPTION
X		D3391-015	AFT TUBE ASSEMBLY
	X	D3391-025	AFT TUBE ASSEMBLY
1	1	D6014-090	AFT TUBE
1	1	D2646	AFT CAP
1	1	D3537-1	WEARPAD
1	1	D3537-7	WEARPAD
1	1	D3553-1	GASKET
1	1	D3553-3	GASKET
14	4	D3670-4200	SPACER
2	2	D3672-1	WASHER
14	14	AELS-1032-130	INSERT
12	12	AELS-1032-225	INSERT
4	4	ALS4-428-165	INSERT
6	6	AN3C4A	BOLT
4	4	AN3C5A	BOLT
10	10	AN960C10L	WASHER



DRILL Ø0.391
C'BORE Ø0.516 X 0.040 DEEP
INSTALL ALS4-428-165 INSERT (1)
(4 PLACES)

D3391-025 ASSEMBLY AND C'BORE DETAIL
(SEE TABLE)



RELEASED
07-11-06

C'BORE HOLES MARKED CB1-CB4 AS FOLLOWS AND
INSTALL AELS-1032-XXX AFTER FINISH AS NOTED

HOLES MARKED	QTY	QTY	C'BORE	P/N
CB1	12	D3391-025	Ø0.430 X 0.170	AELS-1032-225
CB2	4		Ø0.430 X 0.170	AELS-1032-130
CB3	6		Ø0.430 X 0.040	AELS-1032-130
CB4	4		NONE	AELS-1032-130

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W. J. O'NEAL
FEDERAL BUREAU OF INVESTIGATION
U. S. DEPARTMENT OF JUSTICE
WASHINGTON, D. C.
MAY 1960
MEMORANDUM
TO: DIRECTOR